

Work Order ID 67080

Monday, March 07, 2011 2:58:54 PM

Page 1

Item ID: D412-711-101

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Bubble Window

Start Date: 3/7/2011 Start Qty: 2.00

Required Date: 3/11/2011 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D412-711-101	A

100 0.00



DC

Memo

Document Control

Photocopy bluefiles and create labels
for PPP D412-711-101 Change 002

110 0.00



HandThermo

HAND FINISHING THERMOFORMING

Memo

Hand Finishing Thermoforming

Set up Machine as per folio FTA 077 and D711W program using mould DT9640

120 0.00



HandThermo

HAND FINISHING THERMOFORMING

Memo

Hand Finishing Thermoforming

Cut Blanks to 36" by 39"

11/03/09 BG 11-3-15
11 03 16

Sh.
11/03/09

x2 Sh.
11/03/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Monday, March 07, 2011 2:58:54 PM

Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Thermoform Thermoforming Machine	THERMOFORMING MACHINE Memo Thermoform as per Dwg. D412-711-101 using DT 9640 and Folio FTA 077 <u>A</u> Dwg. Rev. <u>A</u> Folio Rev.	0.00 0.00				x2			DL 11/03/09.
140  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo 1) Check Surface finish for undesired marks, voids, dimples etc. □ 2) Check depth of bubble to ensure conformity to drawing tolerances.	0.00 0.00				X	⊕		DL 11/03/09. PTC →
150  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							Substg ⊕

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 412-711-101 PAR #: _____ Fault Category: Thermoforming NCR: Yes No DQA: ✓ Date: 11/03/28
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ✓ Date: 11/03/28

NCR: <u>67080</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/03/09	140	Window Too Deep. At thermoforming machine eye was set up incorrectly. R.C. LOA. <u>✓</u>	<u>h</u> 11.03.15 Q51042	Reset Reposition electronic sensor. Scrap 1 window.	<u>Oh.</u> 11/03/09	<u>S</u> 11/03/15	<u>h</u> 11.03.15	<u>S</u> 11/03/11

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67080

Monday, March 07, 2011 2:58:54 PM



Page 4

Item ID: D412-711-101

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Bubble Window

Start Date: 3/7/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

185



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

11 03 16 2

190



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

11/3/16

200



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/3/16 11-03-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, March 07, 2011 2:58:51 PM

Page 1

Work Order ID: 67080

Parent Item: D412-711-101

Parent Item Name: Replacement Bubble Window



Start Date: 3/7/2011

Required Date: 3/11/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 06-02-01 JLM
Manufacture in-house 10/06/28 DL

IPP Rev. B.

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MACRLICS.236

Purchased

No

sf

168.0000

32



Plexiglass G .236"

Location

Loc Qty

Loc Code

therm

168

115590

8

116030

160

32

Handwritten: 11/03/14.

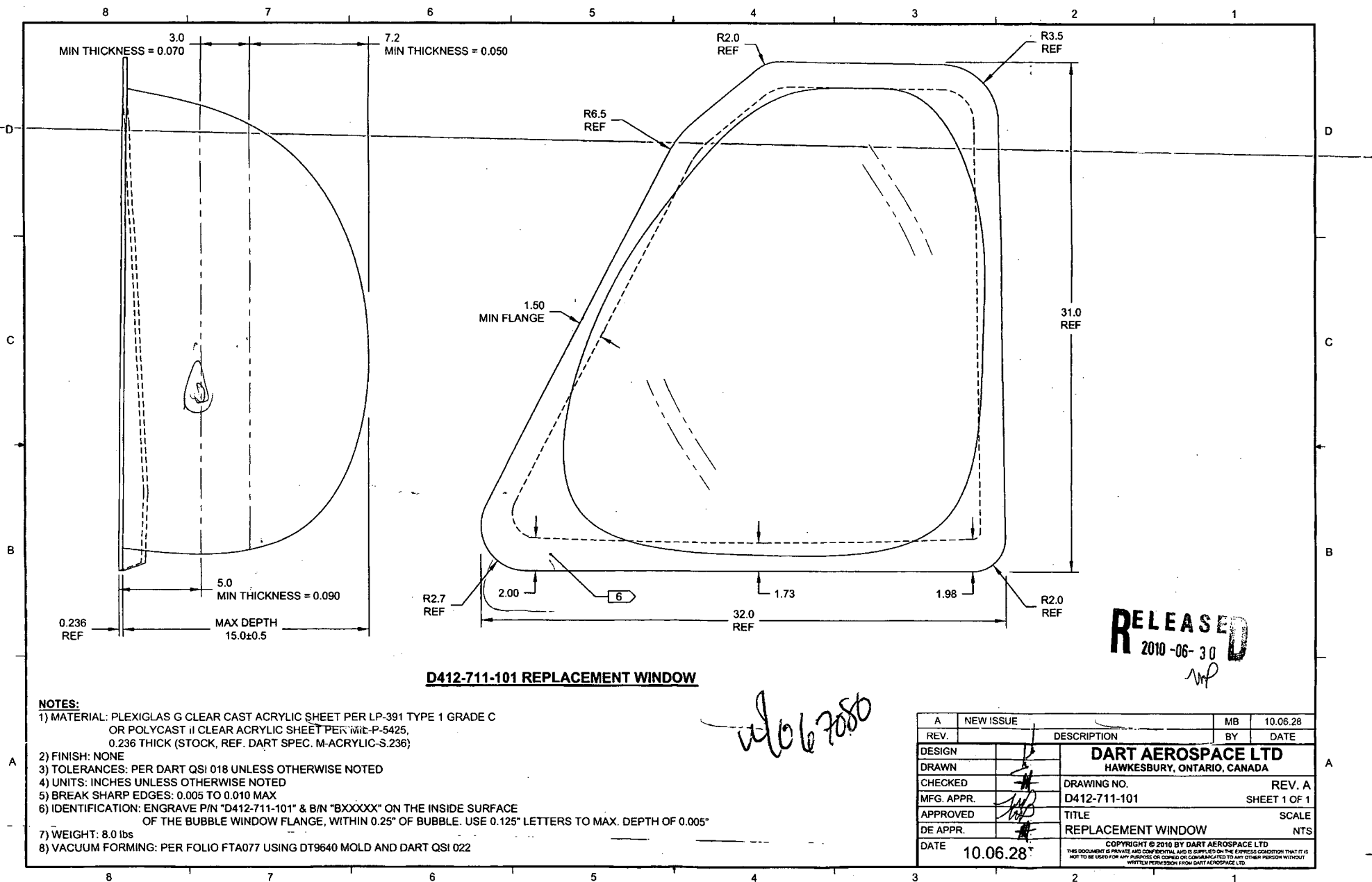
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DART AEROSPACE LTD	Work Order: 67080
Description:	Part Number: 0412-711-101
Inspection Dwg: 0412-711-101 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "	<input checked="" type="checkbox"/>	<input type="checkbox"/>		
Shape Definition	<input checked="" type="checkbox"/>	<input type="checkbox"/>		
Texture Retention	<input checked="" type="checkbox"/>	<input type="checkbox"/>		
Material imperfections such as bumps, cracks, voids, scratching	<input checked="" type="checkbox"/>	<input type="checkbox"/>		
	<input type="checkbox"/>	<input type="checkbox"/>		
	<input type="checkbox"/>	<input type="checkbox"/>		
	<input type="checkbox"/>	<input type="checkbox"/>		
	<input type="checkbox"/>	<input type="checkbox"/>		

Measured by: <u>DL</u>	Date: <u>11/03/09</u>
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.0"	Ref	32.25"	<input checked="" type="checkbox"/>	<input type="checkbox"/>	TAPE DL-01	
31.0"	Ref	31.1"	<input checked="" type="checkbox"/>	<input type="checkbox"/>	TAPE DL-01	
1.5"	MIN.	1.62"	<input checked="" type="checkbox"/>	<input type="checkbox"/>	VERA DL-02	
1.73"	± 0.030 "	1.748"	<input checked="" type="checkbox"/>	<input type="checkbox"/>	VERA DL-02	
2.00"	± 0.030 "	2.017"	<input checked="" type="checkbox"/>	<input type="checkbox"/>	VERA DL-02	
0.090"	MIN	0.091"	<input checked="" type="checkbox"/>	<input type="checkbox"/>	ULTRA	
0.070"	MIN	0.085"	<input checked="" type="checkbox"/>	<input type="checkbox"/>	ULTRA	
0.050"	MIN.	0.077"	<input checked="" type="checkbox"/>	<input type="checkbox"/>	ULTRA	
15.0"	± 0.50 "	15.375"	<input checked="" type="checkbox"/>	<input type="checkbox"/>	TAPE DL-01	
			<input type="checkbox"/>	<input type="checkbox"/>		
			<input type="checkbox"/>	<input type="checkbox"/>		
			<input type="checkbox"/>	<input type="checkbox"/>		

Measured by: <u>DL</u>	Date: <u>11/03/10</u>
Audited by: <u>JB</u>	Date: <u>11/03/10</u>
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10-04-14